



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2807-041
Job Sheet 184591



Part No: D2807-041

Job Qty: 12 ea

Part Name: Prop Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/15/18

Job Tracking No:

Due Date: 10/23/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV E IPP: D 07.11.12 ecn1019, replaces D2807 EC verified by DD IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	12 pcs		10/23/18	0.00	0.00	Purchasing		OCT 25 2018
110	Packaging	12 pcs		10/23/18	0.00	0.00	Packaging2		OCT 25 2018
120	QC	12 pcs		10/23/18	0.00	0.00	QC6		NOV 01 2018
130	Small Fab	12 pcs		10/23/18	0.00	0.24	Small Fab-2		NOV 01 2018
140	QC	12 pcs		10/23/18	0.00	0.00	QC5		NOV 01 2018
150	Packaging	12 pcs		10/23/18	0.00	0.00	Packaging3-1		NOV 06 2018
160	QC21-SA	12 Ea		10/23/18	0.00	0.00	QC21		NOV 06 2018

Part Op 100 - Issue P/O: 41394 Order as per Dwg D2807 Possible supplier: Lift Support
Descriptions: Technologies, Saskatoon, Canada P/N 6/15-164/50-115N
110 - Ensure Material Release Note is attached
130 - 1-Install D3671-1 as per dwg D2807

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3671-1	Placard	12 Ea (1 ea)	100-Purchasing	5120713
6/15-164/50-115N	Gas Spring D2807-041	12 pcs (1 ea)	130-Small Fab	5120045

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D3671-1	12	3	0
130-Small Fab	6/15-164/50-115N	12	0	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Part Specifications

ld not be found.

Plex 10/15/18 7:41 AM dart.lavoie.chantal

Container No: S121317



Part: D2807-041

Job No: 184591

Serial No/Batch: S121317

Revision:

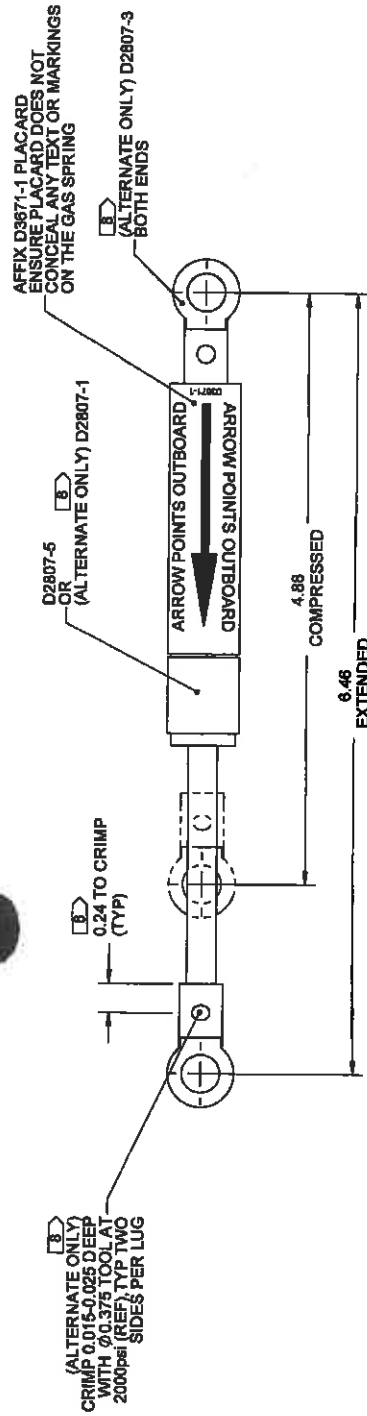
Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/25/18

SPECIFICATION CONTROL DRAWING



D2807-041 GAS SPRING

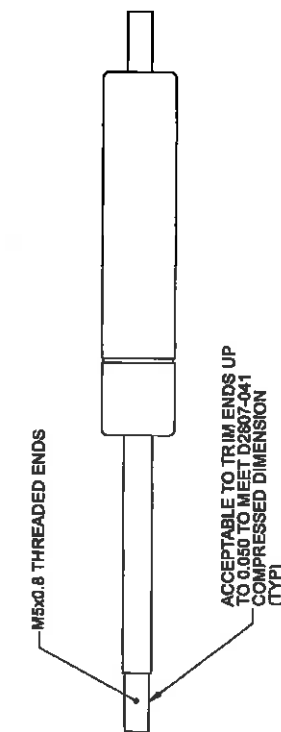
D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3871-1	PLACARD

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK: SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.168 LBS
8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2) (WEIGHT: 0.176 LBS)

E	ADD D2807-5 GAS SPRING; D2807-1-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3871-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	06.05.25
B	ADD FINISH	CP	06.03.19
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	N		
DRAWN	N		
CHECKED	KE		
MFG. APPR.	KE		
APPROVED	KE		
DE APPR.	KE		
DATE	07.12.28		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D2807			
TITLE GAS SPRING			
REV. E SHEET 1 OF 3 SCALE NTS			
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RELEASED



D2807-1 GAS SPRING
SCALE 1:1

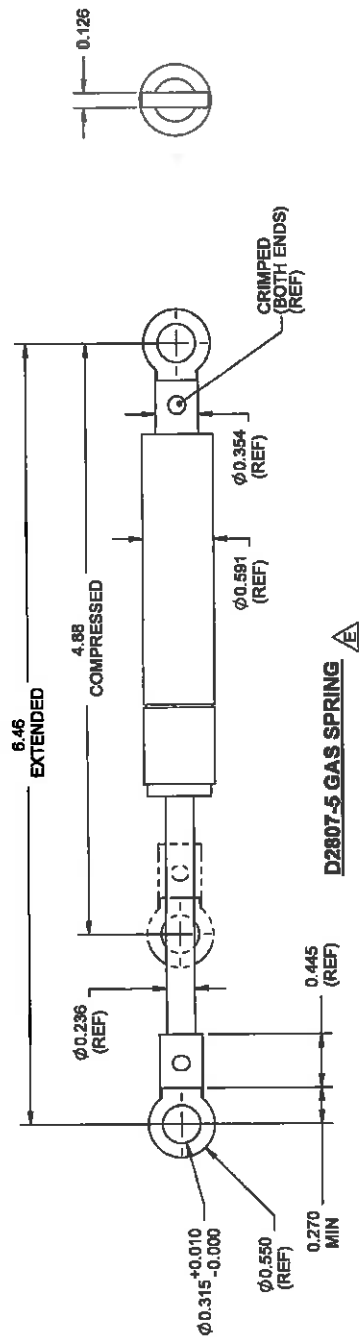
D2407-1 GAS SPRING NOTES:
 (1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
 (P/N: SXT6S905080056L-115N)
 (REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
 (2) FINISH: NONE
 (3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 (4) UNITS: INCHES UNLESS OTHERWISE NOTED
 (5) BREAK SHARP EDGES: N/A
 (6) IDENTIFICATION: N/A
 (7) WEIGHT: 0.144 LBS
 (8) SPECIFICATION: SS GAS SPRING
 ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
 M5X0.8 THREADS

D2807-3 LUG NOTES:
 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
 2) FINISH: NONE. PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) TENSILE: 100,000 PSI. PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) TENSILE ELONGATION: 10% MIN. UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.010 TO 0.015
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.016 LBS

D2807-3 LUG

DESIGN	14	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	14	
CHECKED	14	
MFG. APPR.	14	
APPROVED	14	
DE APPR.	14	REV. E SHEET 2 OF 3
TITLE		SCALE 4:1
DATE	07.12.28	GAS SPRING

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D2807-5 GAS SPRING

- D2807-5 GAS SPRING NOTES:
- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-16480-115N)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.168 LBS
 - 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS, ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	HE	DRAWING NO. D2807
MFG. APPR.	HE	SHEET 3 OF 3
APPROVED	HE	TITLE GAS SPRING
DE APPR.	HE	SCALE 4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041344

Supplier: LST001-VC
LS Technologies Inc.
1634 Saskatchewan Ave.
Saskatoon
SK
S7K 1P6 Canada
Phone: 306 683 5000
Fax: 306 683 6403

PO No: PO041344

PO Date: 10/15/18

Due Date: 10/22/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
OCT 15 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
①	184591	6/15-164/50-115N			Gas Spring D2807-041 As per Dwg D2807 Rev. E	Firmed	-	10/22/18	12 pcs	0 pcs	12 pcs	\$68.37/pcs	\$820.44
							12x	OCT 23 2018					68 9-8
②	184592	B8-240-575-150N			Gas Spring D3552-11 As Per Dwg D3552 Rev. M	Firmed	-	10/22/18	8 pcs	0 pcs	8 pcs	\$41.36/pcs	\$330.88
							8x	OCT 23 2018					
Grand Total:													\$1,151.32

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

CL
[Signature]

Plex 10/15/18 8:01 AM dart.lavoie.chantal

Packing Slip

LS TECHNOLOGIES INC
1634 Saskatchewan Ave
Saskatoon, SK S7K 1P6

P.O. No.	Date	Invoice #
041344 ✓	10/17/2018	19209

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via
10/17/2018	Fed-Ex

Qty	Description
✓ 12	D2807-041 ✓ #184591 Stainless Gas Spring (6/15-164/50-115N)
✓ 8	D3552-11 ✓ #184592 Gas Spring
Shipping Via FED EX Tracking # 773504651766	

Order checked by :





LS Technologies Inc

1634 Saskatchewan Ave,
Saskatoon, SK S7K 1P6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

October 17, 2018

This is to certify that the parts listed below meets specifications as required by your order.

12 Units: D2807-041 #184591 Stainless Gas Spring

8 Units: D3552-11 #184592 Gas Spring

Country of Manufacture: Canada
Date of Manufacture : Oct 2018
This product is ROHS compliant.

Purchase Order # 041344
Invoice # 19209

L S Technologies Inc Canada

A handwritten signature in blue ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
President

DAS
68
9-89

✓ msh 17 Jun 2019

DQA:

Date:

QA Closed:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: 184591 Part No. D2807-041 NCR No. 19-7136		AGAINST DEPARTMENT/PROCESS Cross tube ☐ Water Jet ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☒ Composite ☐ Supplier ☒	
Disposition Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	
Date: NOV 01 2018		QTY Effective: 12	
Step #: 120		MRB (QS1042) Approval 1 MSP 12-11-01	
Description Work Order Deviation - AS PER DWG, PARTS ARE TO BE CRIMPED TYP. TWO SIDES PER LUG. BOTH ENDS CRIMPED ONE SIDE ONLY.			
Completed By 9/10/11			
Lead hand / Supervisor Approval Verification DAS 9 9-89 18-11-01			
QC / QA Coordinator Approval DAS 9 9-89 18-11-01			
Disposition Acceptable. Single crimp is sufficient. Part is not under tension.			
DAS 68 9-89			
- DWG. NO. D2807 REV. E			
FAULT CATEGORY			
Root Cause		Temperature/Cure	
Environment ☐ Design ☒ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Power Loss/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☒ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	
OTHER:			